



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4034-041

Job Sheet 199770



Part No: D4034-041

Job Qty: 4 pcs

Part Name: Aft Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/30/19

Job Tracking No:

Due Date: 9/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA
10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER
DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	4 pcs	9/20/19	9/20/19	0.00	1.60	Large Fab - 1		MAL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	4 pcs	9/20/19	9/20/19	0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	9/20/19	9/20/19	0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S222435



Part: D4034-041

Job No: 199770

Serial No/Batch: S222435

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/15/19

Plex 8/30/19 9:59 AM Dart.lajeunesse.marie

130 Packaging 3-1 - Stock - B4B 4 pcs	9/20/19	0.00 0.00	QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	MAL
			Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B				
Packaging 3 - 9 - B4B				
Packaging 3 - 10 - B4B				
Packaging 3 - 11 - B4B				
Packaging 3 - 12 - B4B				
Packaging 3 - 13 - B4B				
Packaging 3 - 14 - B4B				
Packaging 3 - 15 - B4B				
Packaging 3 - 16 - B4B				
Packaging 3 - 17 - B4B				
Packaging 3 - 18 - B4B				
Packaging 3 - 19 - B4B				
Packaging 3 - 20 - B4B				
Packaging 3 - 21 - B4B				
Packaging 3 - 22 - B4B				
Packaging 3 - 23 - B4B				
Packaging 3 - 24 - B4B				
Packaging 3 - 25 - B4B				
Packaging 3 - 26 - B4B				
Packaging 3 - 27 - B4B				
Packaging 3 - 28 - B4B				
Packaging 3 - 29 - B4B				
Packaging 3 - 30 - B4B				
Packaging 3 - 31 - B4B				
Packaging 3 - 32 - B4B				
Packaging 3 - 33 - B4B				
Packaging 3 - 34 - B4B				
Packaging 3 - 35 - B4B				
Packaging 3 - 36 - B4B				
140 QC 21 - SA 4 pcs	9/20/19	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-89

OCT 16 2019

OCT 16 2019

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: M13905) 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld
 Descriptions: bushing in rib and grind weld flush as per dwg
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____) LOCATION: WA004-5
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 pcs (1 ea)	100-Large Fab - Basket - 1	5220420
D4021-9	Bushing	16 pcs (4 ea)	100-Large Fab - Basket - 1	5210140
D4034-1	Rib	4 pcs (1 ea)	100-Large Fab - Basket - 1	2x5214565 / 2x5204607
D4034-3	Rib	4 pcs (1 ea)	100-Large Fab - Basket - 1	5216430

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D4021-7	4	0	0
	D4021-9	16	187	0
	D4034-1	4	22	0
	D4034-3	4	22	0
Part Specifications				
Specifications could not be found.				

Plex 8/30/19 9:59 AM Dart.lajeunesse.marie

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				Date: _____ Sequence #: _____ QTY Affected: _____ MRB (QS1042) _____																																																																											
Description Work Order Deviation						Disposition		Completed By																																																																											
Root Cause <table border="1"> <tr> <td>Operator</td><td>☐</td> </tr> <tr> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> </tr> <tr> <td>Handling/Preservation</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> </tr> <tr> <td>Product Improvement</td><td>☐</td> </tr> <tr> <td>Process Improvement</td><td>☐</td> </tr> <tr> <td>Human Factors</td><td>☐</td> </tr> </table>						Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Bending</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Tolerance</td><td>☐</td> </tr> <tr> <td>Crushing</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain Direction</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td> <td>Incomplete/Unclear Instructions</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Mislabeled</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Off-set/Set-up</td><td>☐</td> <td></td><td></td> </tr> </table>				Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐			Lead hand / Supervisor _____	
						Operator	☐																																																																												
						Manufacturing Process	☐																																																																												
Equip/Tooling	☐																																																																																		
Handling/Preservation	☐																																																																																		
Material	☐																																																																																		
Product Improvement	☐																																																																																		
Process Improvement	☐																																																																																		
Human Factors	☐																																																																																		
Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐																																																																												
Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐																																																																												
Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐																																																																												
Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐																																																																												
Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																												
Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐																																																																												
Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐																																																																														
				QC / QA Coordinator _____																																																																															